

Work Order ID 54825

December 22, 2009 1:29:10 PM



Page 1

Item ID: D3705-5

Accept



Setup Start



Revision ID:

Item Name: Access Panel

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CZ

Date: 09/12/23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3705

Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

RB 10-1-7

FLOW CNC Waterjet

6061 .040

1-Cut as per Dwg D3705 || Dwg Rev: C || Prog
Rev: C || 2- Deburr if necessary



110

QC2- Inspect parts off machine FAI/FAIB

0.00

RB 10-1-7

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

25/10/07



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Setup Start



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Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

AS

0.00

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-01-7

0.00

(9)

✓

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54825

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Item ID: D3705-5

Accept



Setup Start



Revision ID:

Item Name: Access Panel

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M109091

Memo

0.00

⇒ M 10-01-13

(X9) P

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10-01-13

(9) P

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

P10/01/14 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3705-5

Accept



Setup Start



Revision ID:

Item Name: Access Panel

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp10/01/15 *MF*MF
10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54825



Parent Item: D3705-5



Parent Item Name: Access Panel

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No			sf	210.4102	1.2800	3.0		HR 10-1-7

6061-T6 .040 Sheet

Warehouse

Location

Main Warehouse

MAT	210.4102	
100742	3.3	
102723	5.93	
105842	12	
106747	5.7516	
107461	11.7841	107461
109396	17.9316	
111224	23.0629	
113004	129.15	
19380	1.5	

9

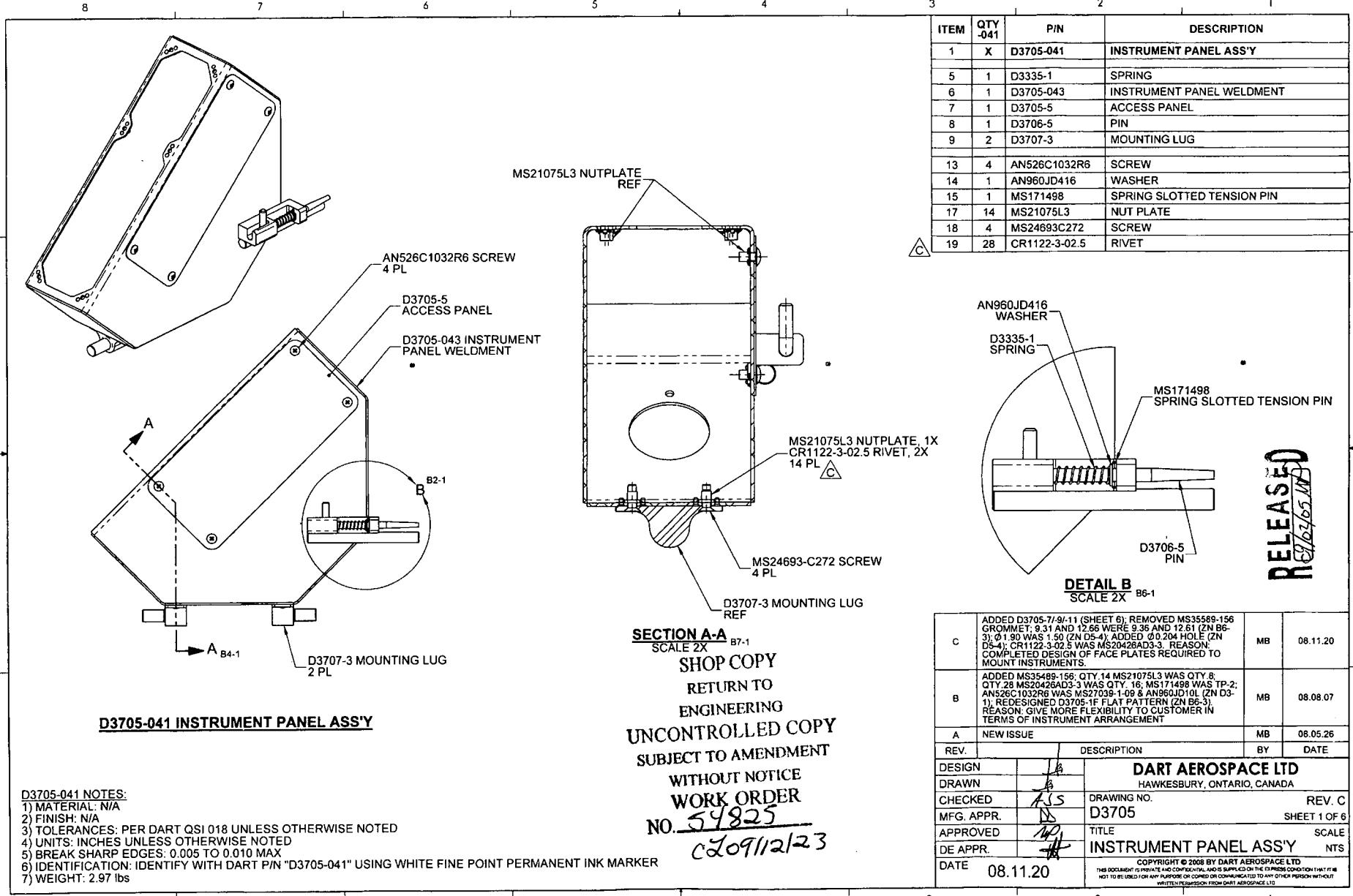
DART AEROSPACE LTD	Work Order:	54825
Description: ACCESS PANEL	Part Number:	D3705-5
Inspection Dwg: D3705-4 Rev: C		Page 1 of 1

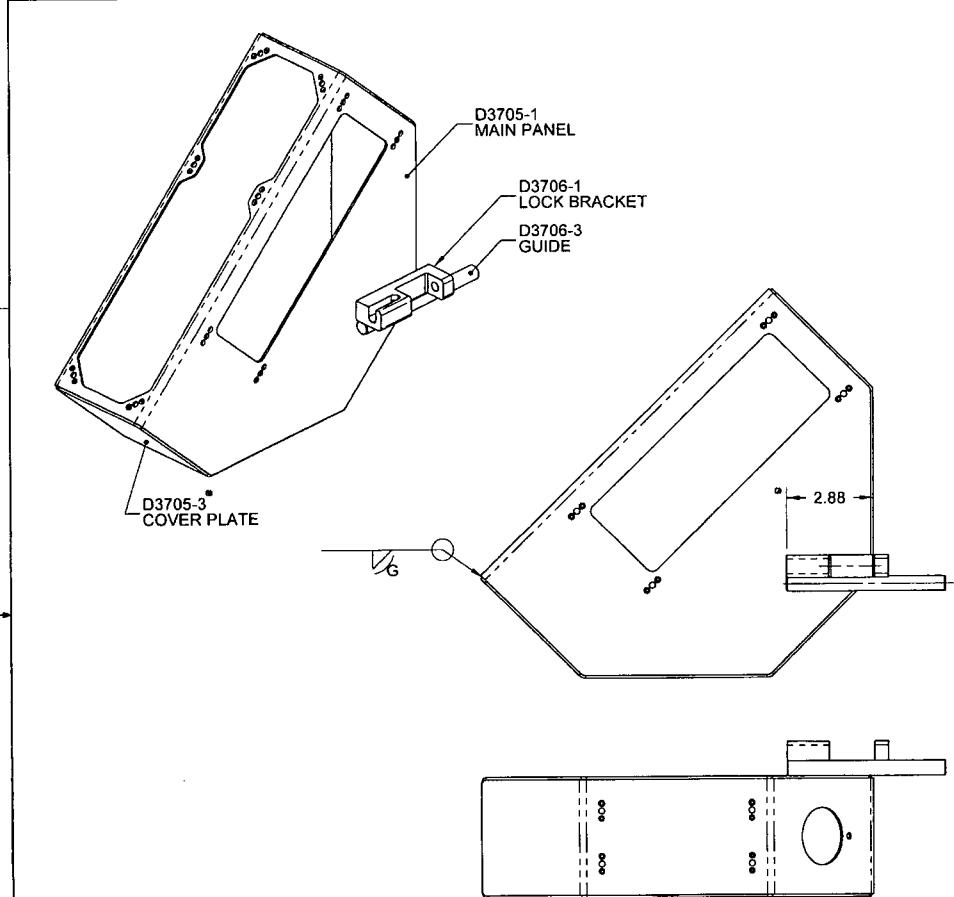
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HR	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-7	Date:	16/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





D3705-043 INSTRUMENT PANEL WELDMENT

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

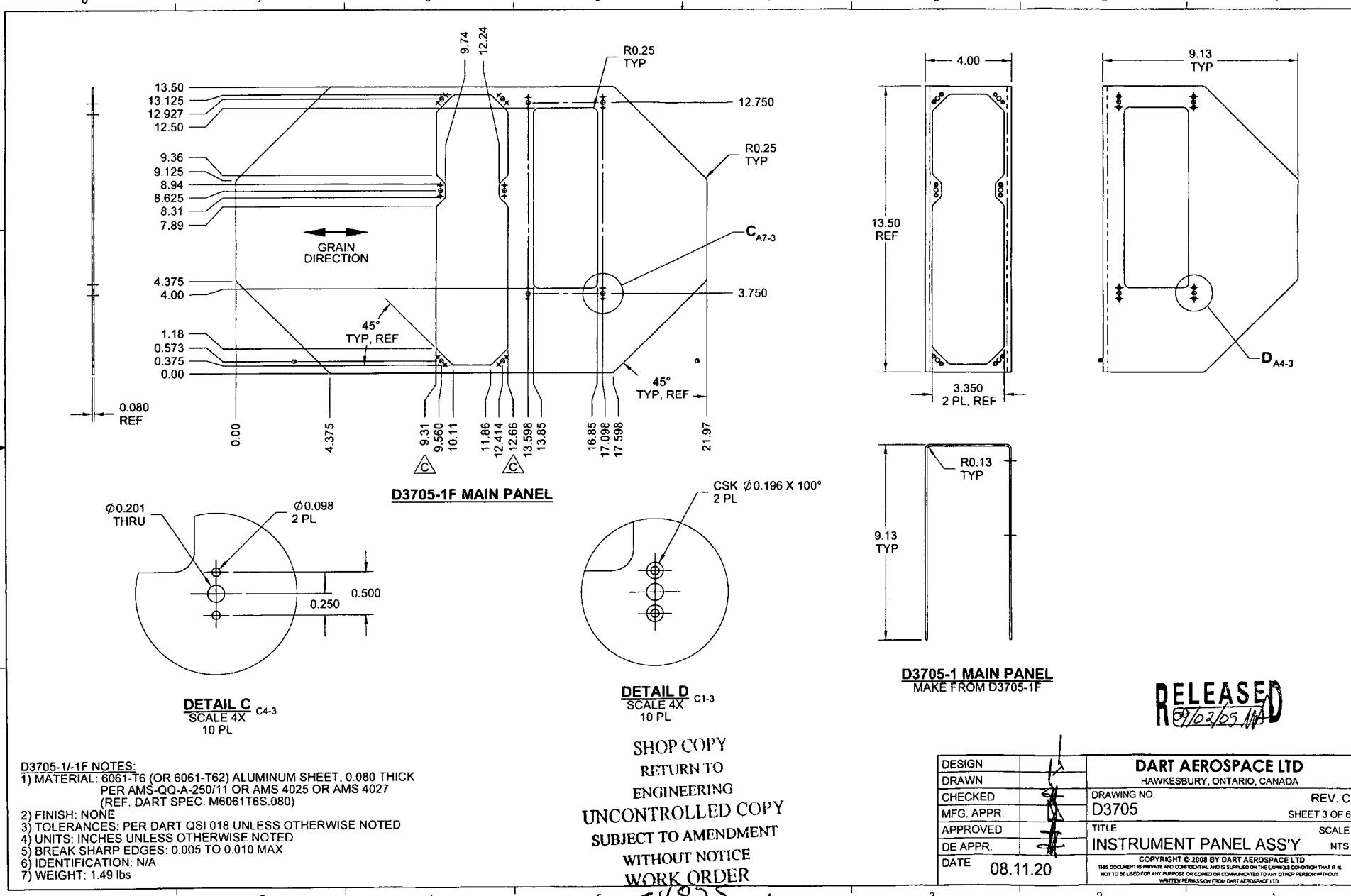
ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE

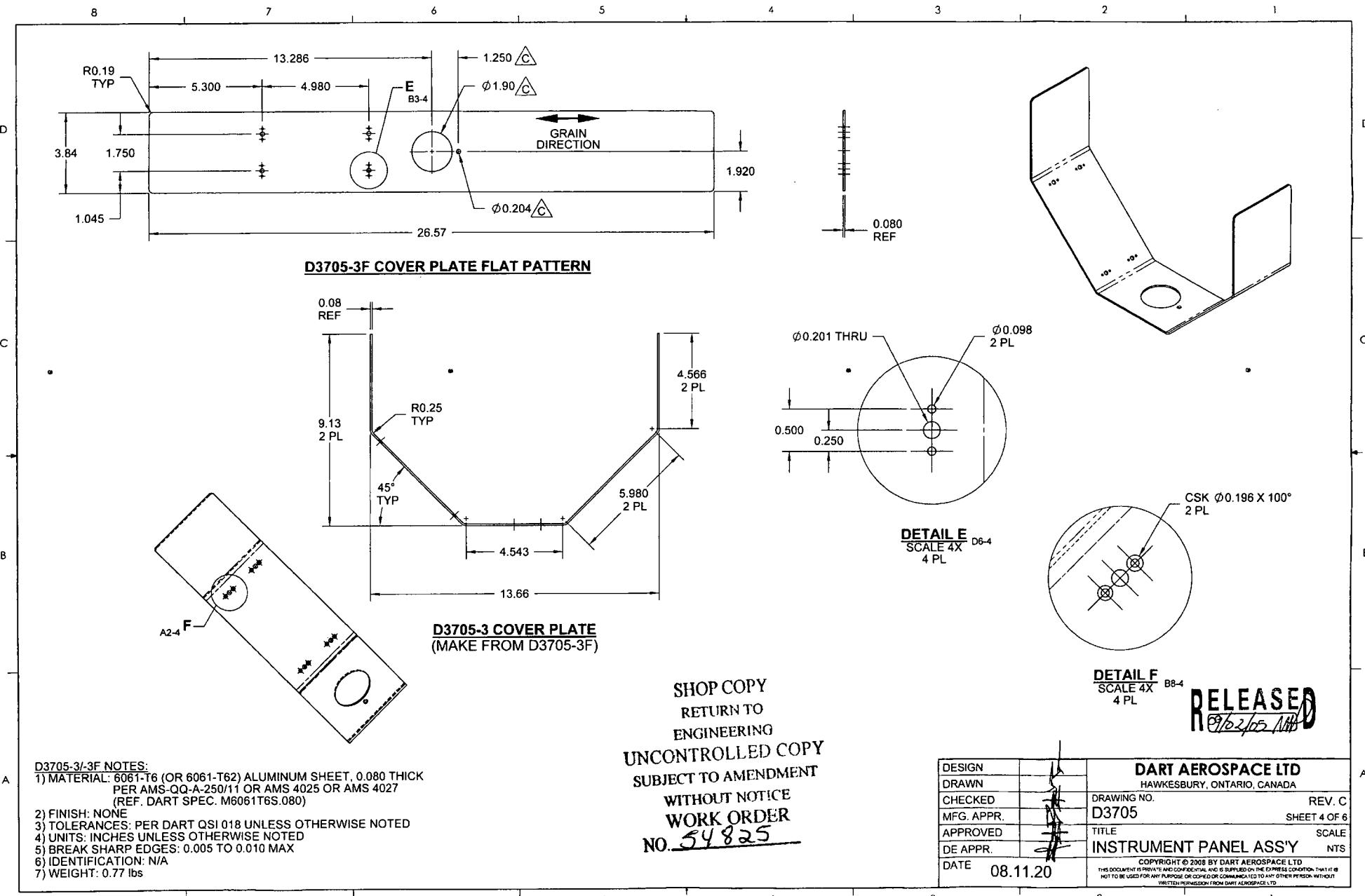
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54825

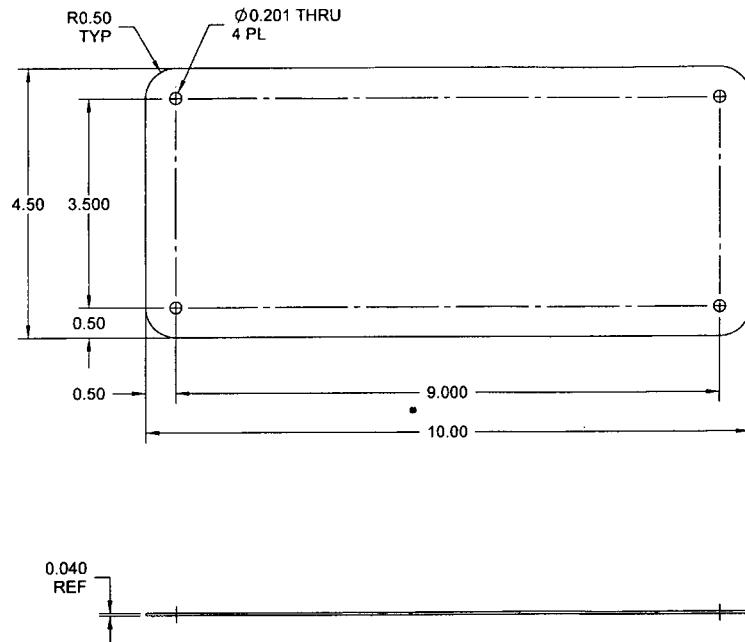
RELEASED
8/26/05 MHD

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO. D3705
MFG. APPR.	<i>1</i>	REV. C
APPROVED	<i>1</i>	SHEET 2 OF 6
DE APPR.	<i>1</i>	TITLE INSTRUMENT PANEL ASSY
DATE 08.11.20	<i>1</i>	SCALE NTS

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D3705-5 ACCESS PANEL

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54825

RELEASED
09/02/05 *[Signature]*

D3705-5 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S,040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE
8) WEIGHT: 0.17 lbs

DESIGN	<u>15</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<u>15</u>			
CHECKED	<u>15</u>	DRAWING NO.	REV. C	
MFG. APPR.	<u>15</u>	D3705	SHEET 5 OF 6	
APPROVED	<u>15</u>	TITLE	SCALE	
DE APPR.	<u>15</u>	INSTRUMENT PANEL ASSY	NTS	
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